

Date: Friday, 23/01/2009 2:58:44 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INBOARD LEG ASS'Y
Job Number : 45218
Estimate Number : 13174
P.O. Number :
This Issue : 23/01/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : MACHINED PARTS
Previous Run : 44524
Written By :
Checked & Approved By : MF 09-01-23
Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM
Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC
Est Rev:C Added sealant note as per Rev C 09-01-20 JLM
Verified By:DD

Part Number : D3684045
Drawing Number : D3684 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 28/01/2009 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D36885 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

STUD

batch: B344685

MF 09-01-28

3.0 D36891 SLEEVE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SLEEVE

batch: 44687

MF 09-01-28

4.0 D36911 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

STUD

batch: 44688

MF 09-01-28

5.0 D36921 SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch: 44527

MF 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD LEG ASS'Y

Job Number: 45218

Part Number: D3684045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod End Bearing

batch B44691

mf 09-01-27

7.0

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolts

batch 106993

mf 09-01-27

8.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch 110023

mf 09-01-27

9.0

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nuts

batch 106993

mf 09-01-27

10.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nuts

batch 106993

mf 09-01-27

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

①
090128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD LEG ASS'Y

Job Number: 45218

Part Number: D3684045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5026128 (XU)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

44424

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/29

Job Completion



NF 09-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

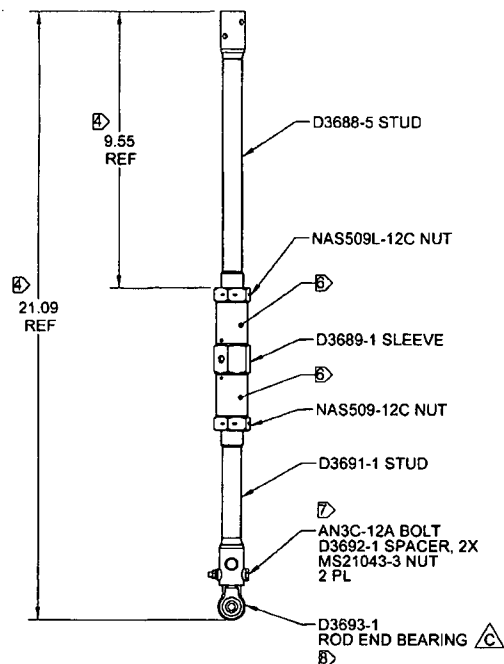
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-045 INBOARD LEG ASSEMBLY



NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3684	REV. C
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

